

# Work Order ID 66718

Thursday, February 24, 2011 1:11:13 PM

Page 1

Item ID: D2346

Accept

Revision ID:

Item Name: Spacer

Start Date: 2/24/2011 Start Qty: 4.00

Required Date: 2/24/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *mf*

Date: 11-02-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2346

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA198 Deburr

*11.2.24*

*4*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11.2.24*

*4*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*11.02.24*

*4*

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Thursday, February 24, 2011 1:11:13 PM



Page 2

Item ID: D2346

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 2/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 BR 11-2-24

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 of 11 11/02/2011

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/2/24 40 P

**Work Order ID 66718**

Thursday, February 24, 2011 1:11:13 PM



Page 3

Item ID: D2346

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 2/24/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 DJ

MF

11-02-24

# Picklist Print

Thursday, February 24, 2011 1:11:04 PM

Page 1

Work Order ID: 66718



Parent Item: D2346

Parent Item Name: Spacer

Start Date: 2/24/2011

Required Date: 2/24/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP G02.03.05 Re-format to machine in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.035 		Purchased	No			100	f	235.5117	0.1042	0.438737		11-2-24	
6061-T6 RD Tube .375 x.035W													

Location

Loc Qty

Loc Code

MAT014

235.511716

104913

37.2904

12652

198.221316

416



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2346	REV. 8 SHEET 1 OF 1
DATE 99.12.15		TITLE SPACER	SCALE 2:1
A	95.01.05	NEW ISSUE	
B	99.12.15	ADD FINISHING	

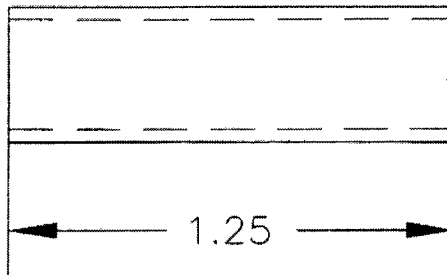
RELEASED  
19.12.21 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
JB BEFORE MANUFACTURE

H 66718



MATERIAL: 6061-T6 (WW-T-700/6) 0.375 DIA x 0.035 WALL  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES 0.010 TO 0.020

